Dart Aerospace Ltd.

Date: Tuesday, 10/17/2006 11:01:55 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 129034		
Estimate Number	: 10262		
P.O. Number	: N/A	**Part Number**	: D350636011
This Issue	: 10/17/2006 **S.O. No.** : N/A	**Drawing Number**	: D2750
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 29033	**Material**	: N/A
Written By	:	**Due Date**	: 11/10/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: KJ 06 10 17		

Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ
Est Rev:J 06-03-23 As per Rev D JLM
Est Rev:J 06-07.13 As per dsi9343 EC

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-011 CHG 002 06-10-18 KJ ①

2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	329327

IT 06-12-20

3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch 327559 BE 07-01-08

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

IT 06-12-20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

QA: N/C Closed: _____ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:01:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034
Part Number: D350636011

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

4-Drill pilot holes for Detail B using DT8330 ZT 06-12-20

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube******

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Grind welds flush as per Dwg D2750 BE 07-01-08

9-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750

10-Weld D2744 Cap as per Dwg D2750 and QSI 004 Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M102756 BE 07-01-08

11-Countersink Detail A as per dwg D2750. BE 07-01-08

12- Scribe batch# inside per dwg D2750 BE 07-01-08

Seq. #	Machine Or Operation	Description
5.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION M 07/01/08 (1)

Seq. #	Machine Or Operation	Description
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP M 07/01/08 (1)

Seq. #	Machine Or Operation	Description
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 — Pm 07-01-08 (1)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Seq. #	Machine Or Operation	Description
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION BE 07-01-08 (1)

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034 **Part Number:** D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	D2739	350 I Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Web Batch: B29010 Pm/JB 07-01-09 ①

10.0	D34901	CROSS BOLT SPACER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer Batch: B29360 BE 07-01-10

11.0	D34903	CROSS BOLT SPACER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Crossbolt spacer Batch: B29362 BE 07-01-10

12.0	D2743	Crossbolt Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Crossbolt Spacer Batch: B29342 BE 07-01-10

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) Pm 07-01-08 ① as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side) Pm 07-01-08 ① as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4) Pm 07-01-08

4-Deburr and blow out all chips from inside of tube Pm 07-01-08 ①

6-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: 102 672 Pm/JB 07-01-07
exp. date: 07-02-01

 Form: rproc

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)
A/R Aluminum Rod batch: M 102756 BE 07-01-10

8-Grind welds flush as per Dwg D2750 PM 07-01-11 ①

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 PM 07-01-11 ①

10-Deburr holes PM 07-01-11 ①

Seq. #:	Machine Or Operation:	Description :
14.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/01/15 ①

15.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/01/15 ①

16.0	POWDER COATING	POWDER COATING

M103141 ①

Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3 MH 07/01/31

17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024 a.m 07/02/05 ①

18.0	NAS1330S3KB166	INSERT

Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)
INSERT
Batch: M103482

19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Install inserts as per Dwg D2750 07/02/05 x 1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 10/17/2006 11:01:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034 | **Part Number:** D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
Inspect Inserts
07/02/05

21.0	D26483	Wearpad

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Wearpad
Batch: 28249

22.0	D265613	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 29009

23.0	D265635	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 28253

24.0	D2746	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: 29012

25.0	D2745	Bushing

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: 29437

26.0	D3488041	BLADE FITTING ASSEMBLY, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade Fitting, LH
Batch: 28318
07/02/05

 Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:01:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	D3492041	PLUG ASSEMBLY

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 29983

Seq. #:	Machine Or Operation:	Description :
28.0	D3492043	PLUG ASSEMBLY

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 29364

Seq. #:	Machine Or Operation:	Description :
29.0	AN3C5A	Bolt

Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)
Bolt
Batch: 102929 X 9 103395 X 29

Seq. #:	Machine Or Operation:	Description :
30.0	AN3C6A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 101418

Seq. #:	Machine Or Operation:	Description :
31.0	AN3C7A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: 102254

Seq. #:	Machine Or Operation:	Description :
32.0	AN6C44A	BOLT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: 103324

Seq. #:	Machine Or Operation:	Description :
33.0	AN8C35A	BOLT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT
Batch: 102180

KC 07/02/05

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:01:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	AN960C10L	washer
	Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s) washer Batch: 103344	
35.0	AN960C816L	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: 100186	
36.0	MS210436	NUT
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) NUT Batch: 102532	
37.0	MS21083C8	NUT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) NUT Batch: 100186	
38.0	NAS1515H3L	WASHER
	Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s) WASHER Batch: 102724	
39.0	NAS1515H8L	WASHER
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s) WASHER Batch: 102535	JL 07/02/05
40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: 103345	JL 07/02/05

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:01:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: 102672
EXP DATE: 02/07

YL 07/02/06

hardware had to be switched around.

4-Coat all exposed fasteners with "LPS Procyon" batch: 17168

41.0 QC5 — INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

42.0 PACKAGING 1 — PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

07/2/23

43.0 D2741 — Blade

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
✓ Blade
Batch: B29868

44.0 AN960C816L — WASHER

✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M100186

45.0 MS21083C8 — NUT

✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M100186

46.0 AN8C21A — BOLT

✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M103547 1X M103385 1X

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/02/06

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action	Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 10/17/2006 11:01:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29034

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
47.0	NAS1515H8L ✓	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: M102516-	
48.0	D34931 ✓	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: 329778-	
49.0	D35321 ✓	spacer
	Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s) batch: 327894	7/2/23 (1)
50.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	07/02/23
51.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Package as per PPP D350-636-011 REV: E	07/02/23
52.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) 07/02/26

Job Completion

U 07.02.26

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS

A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157

RELEASED 06.02.07

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

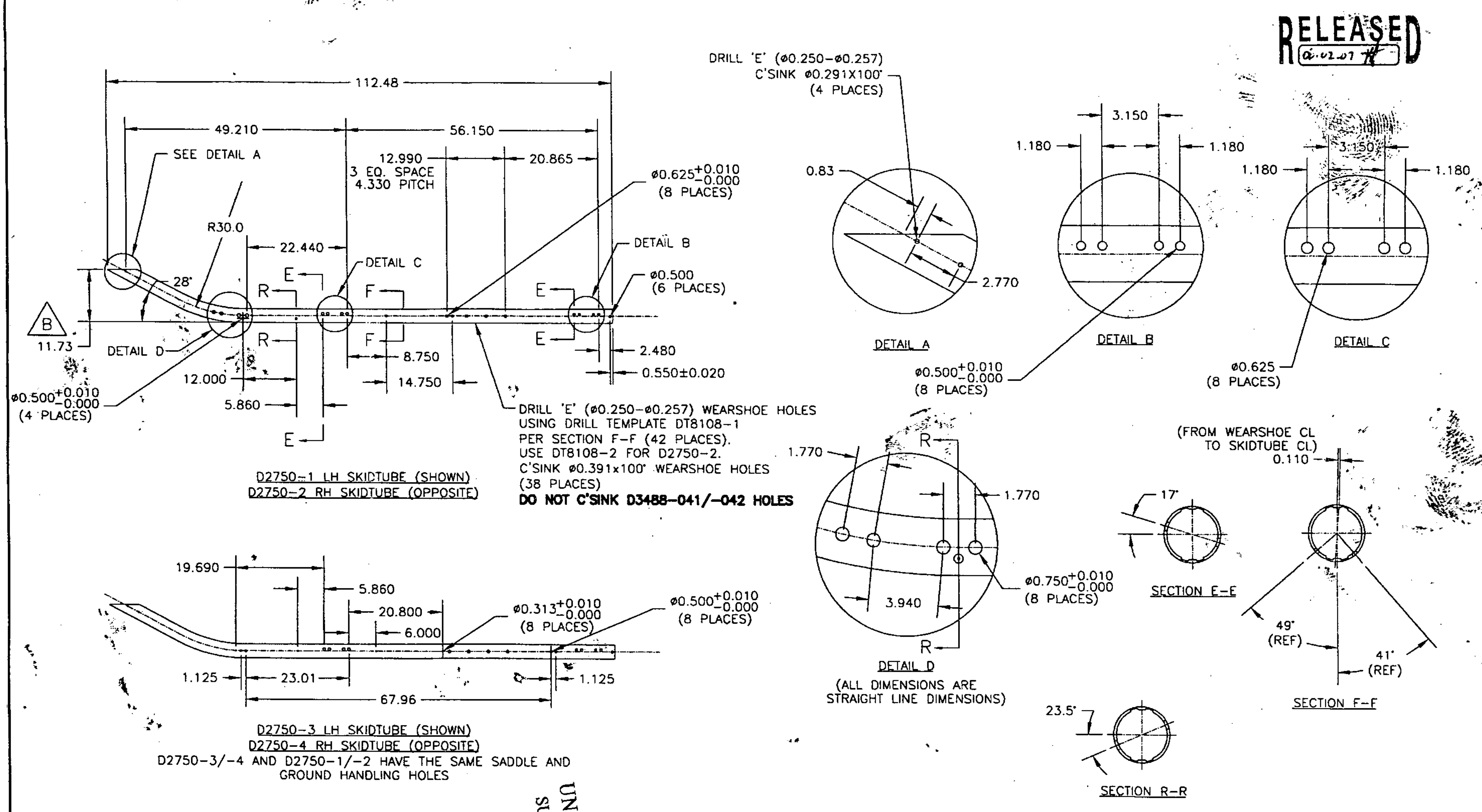
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS

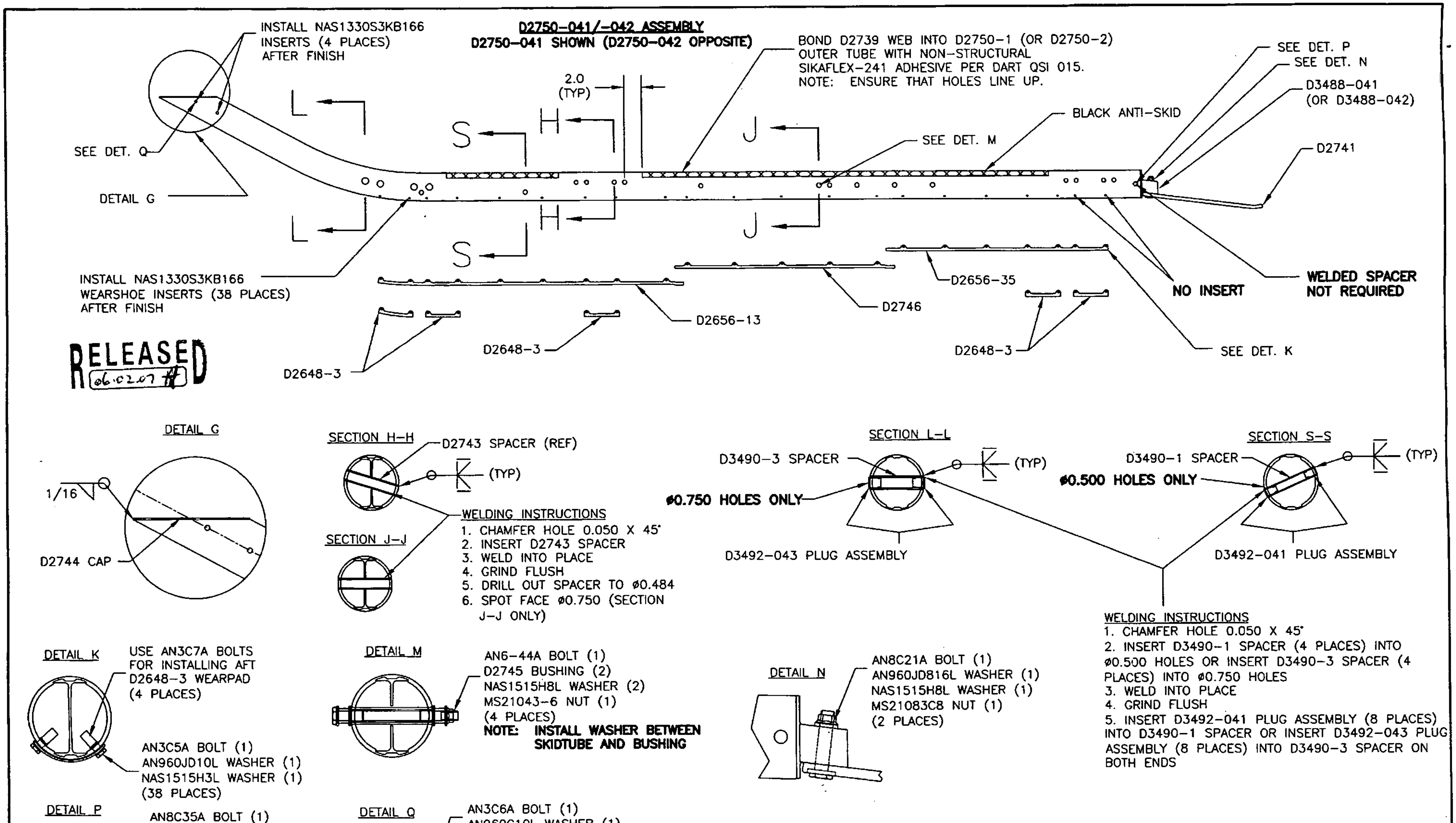
RELEASED 06.02.07

GENERAL NOTES:

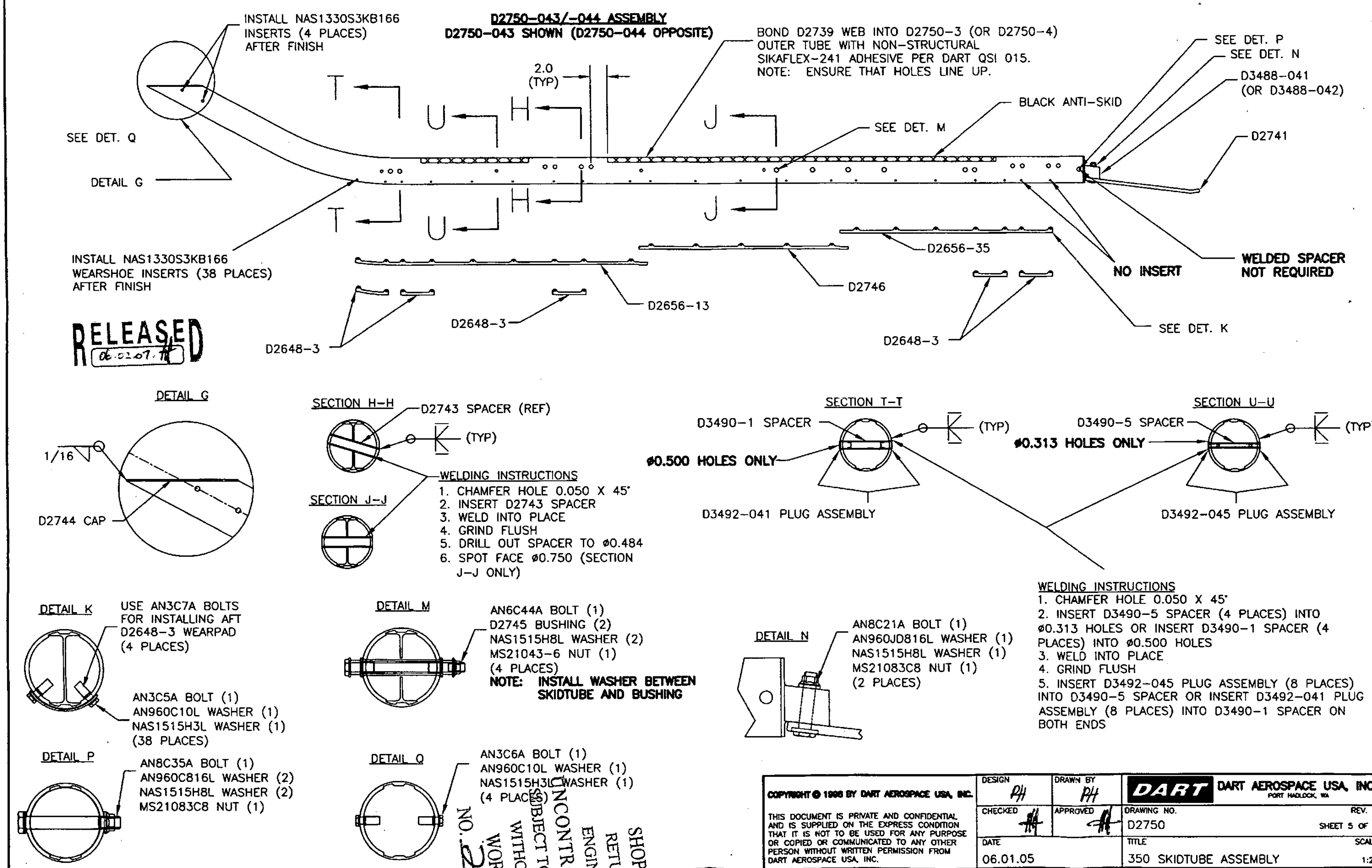
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
   ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES (Ø0.250- Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391 X 100° AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX –241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
PH	PH			
CHECKED	APPROVED	DRAWING NO. D2750	REV. D	SHEET 3 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20	



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	DRAWING NO. D2750 — REV. D — SHEET 4 OF 5
CHECKED	APPROVED	TITLE: 350 SKIDTUBE ASSEMBLY
DATE: 06.01.05		SCALE 1:20



DESIGN: PH
DRAWN BY: PH
CHECKED: [initials]
APPROVED: [initials]
DATE: 06.01.05

DART AEROSPACE USA, INC. PORT HADLOCK, WA

DRAWING NO. D2750 — REV. D — SHEET 5 OF 5

TITLE: 350 SKIDTUBE ASSEMBLY — SCALE 1:20

NO. 82

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A350 636 0 11 / B29428

TEST WELDS REQUIRED

BASE METAL Alum
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS Tig
Single Weld [✓] **Double Weld** [ ]
Backing YES [ ] NO [✓]

	Position			
		Vertical Down [ ]	Up [ ]	
Sheet Groove	1G [ ]	2G [✓]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [✓]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [✓]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [✓]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into ______________ Skidtube

TEST RESULTS

Visual Pass [✓] Fail [ ]
Penetration Pass [✓] Fail [ ]

Crossbolt Spacer Pass [✓] Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/12/18 **Qualifier** David Duval

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Monday, February 05, 2007 1:10 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: sikaflex-291

Jason,
Yes.
Bill

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 5, 2007 12:49 PM
To: 'Bill Beckett'
Subject: sikaflex-291

Bill,
We have 25 tubes of sikaflex-291,batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com
Q.C. COORDINATOR